

**Work Order ID 69712**

Tuesday, May 17, 2011 2:28:06 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 5/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:   H  Date: 11-05-12

Tooling:

Date:           

Run Start

QC:           Date:           SPC (Y/N):           Date:           

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

8/10/14

CK Row Ch 11/67/13

B69712

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69712

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

11/06/17

W/O:		WORK ORDER CHANGES					
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[illegible]

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**Accept**

[illegible]**Setup Start**

**Stop**

\_\_\_\_\_

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

**Stop**

### Operation Description

### Set Up/ Run Hours

## Tool ID

**Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐

12-Grind welds flush as per Dwg D2750

120



QC

## Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

## Memo

0.00

130

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QC

## Quality Control

QC5- Inspect part completeness to step on W/O

0.00

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 69712**

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Item ID: D350-636-012

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Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 5/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

*He*

11-06-21

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

*8/16/2011*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**Work Order ID 69712**

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Item ID: D350-636-012

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Revision ID:

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Item Name: Skidtube RH

Start Date: 5/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☒ Sikaflex-291

batch: 116945

exp. date: 12/31/15

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod

batch: M117456

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

(X)

BB 11/06/23

BB 11/06/23

BB 11/06/27

BB 11/06/27

BB 11/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

\_\_\_\_\_

Page 6

**Accept**

**Setup Start**

[REDACTED]

**Stop**

[illegible]**Cust Item ID:**[illegible]

**Customer:**

Run Start

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

**Stop**

[illegible]

### Operation Description

### Set Up/ Run Hours

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

dwg D2750

12-Deburr holes

170

QC

## Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

## Memo

0.00

180

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project.

QC

## Quality Control

QC5- Inspect part completeness to step on W/O

0.00

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 69712**

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Revision ID:

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Start Date: 5/17/2011 Start Qty: 1.00

Required Date: 6/2/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1  $\phi$  BL 11-8-6

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00  
320 °F  
2:301X  $\phi$  M-11/07/07

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1  $\phi$  HL 11/07/13

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
HandFinish	Memo	0.00				1	0	24	u107113
Hand Finishing	Install inserts as per dwg D2750								
230	HandFinishing	0.00							
HandFinish	Memo	0.00				1	0	24	u107113
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>NIA</u>								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M117516</u> EXP DATE: <u>12/01</u>								
	4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: <u>KA104189</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M114596</u>								

W/O:		WORK ORDER CHANGES					
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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69712**

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Page 10

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 5/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

REV F

11/7/15

CK 4/07/15

ME  
11-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Tuesday, May 17, 2011 2:28:12 PM

Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq110 DD verf: EC IPP Rev: P 10.10.01 as per  
 IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	1,685.000	38	38			
Insert													

Location	Loc Qty	Loc Code
FP-B	4	
110768	4	
ST282	1681	
110768	881	
117717	800	

AN3C5A		Purchased	No			230	Each	1,290.000	34	34			
Bolt													

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1283	
115422	49	
116419	334	
116549	100	
117343	500	
117508	300	

10

HL 1107113

34

HL 1107113

1117872 x34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 17, 2011 2:28:12 PM

Page 2

Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

422.0000

4

4



BOLT



11/07/13

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

421

111982

2

116419

23

116549

50

116704

96

117514

100

117619

50

117688

100

11/07/13

AN6C44A

Purchased

No

230

Each

82.0000

4

4



BOLT



11/07/13

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

80

117407

80

1117763

11/07/13

AN8C35A

Purchased

No

230

Each

69.0000

1

1



BOLT



11/07/13

Location

Loc Qty

Loc Code

FP

40

117511

40

FP-A

29

115960

6

116874

23

11/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 17, 2011 2:28:13 PM

Page 3

Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

230

Each

0.0000

38

38



washer

1118179



(x38) M 1107113

AN960C816L Purchased No

230

Each

0.0000

1

1



WASHER NAS1149C0832R

1114915



(x1) M 1107113

D2745 Manufactured No

230

Each

206.0000

8

8



Bushing



M 1107113

## Location

## Loc Qty

## Loc Code

FP-A

206

67764

5

68248

201

D3488-042 Manufactured No

230

Each

24.0000

1

1



Blade Fitting Assembly, RH



M 1107113

## Location

## Loc Qty

## Loc Code

FP008

24

62003

4

65099

8

68109

12

D3492-1 Manufactured No

230

Each

0.0000

8

8



Plug

1370689



(x8) M 1107113

D3492-3 Manufactured No

230

Each

0.0000

8

8



Plug

1370692



(x8) M 1107113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 69712

Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 5/17/2011



Required Date: 6/2/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-25      Manufactured      No      230      Each      30.0000      1      1  
            HL 11/07/13  
 Wearshoe



Location	Loc Qty	Loc Code
FP018	30	
62233	1	
65167	3	
68353	11	
<u>69284</u>	15	

D3536-25      Manufactured      No      230      Each      34.0000      1      1  
            HL 11/07/13  
 Gasket

Location	Loc Qty	Loc Code
FP012	34	
65903	8	
<u>68351</u>	26	

D3537-1      Manufactured      No      230      Each      35.0000      3      3  
            HL 11/07/13  
 Wearpad

Location	Loc Qty	Loc Code
FP017	35	
63313	2	B70686
66804	29	
66935	4	

D3631-1      Manufactured      No      230      Each      500.0000      8      8  
            HL 11/07/13  
 Washer

Location	Loc Qty	Loc Code
ST072	500	
<u>68062</u>	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 69712

Parent Item: D350-636-012


Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011


Start Qty: 1.00

Required Qty: 1.00

D3672-1      Manufactured      No      230      Each      1,350.000      8      8  
  
 Phenolic Washer


Location      Loc Qty      Loc Code

ST074      1350  
 64177      850  
 66821      500

D3791-1      Manufactured      No      230      Each      19.0000      1      1  
  
 Wearplate


Location      Loc Qty      Loc Code

FP017      19  
 62239      7  
 68352      12

D3793-1      Manufactured      No      230      Each      31.0000      1      1  
  
 Wearshoe

Location      Loc Qty      Loc Code

FP018      31  
 64445      14  
 69285      17

D3793-3      Manufactured      No      230      Each      30.0000      1      1  
  
 Wearshoe

Location      Loc Qty      Loc Code

FP018      21  
 68356      13  
 69283      8  
 FP019      9  
 64447      9

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/07/13	236	Assemble with NAS1515H36 / W113362 washers  Permanent change!	JH	11/07/13	x4		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230 Each

32.0000 1 1



Gasket



HL 11/07/13

Location

Loc Qty

Loc Code

FP010

32

39421

1

61704

5

68355

26

D3794-3

Manufactured No

230 Each

34.0000 1 1



Gasket



HL 11/07/13

Location

Loc Qty

Loc Code

FP010

26

68357

26

FP018

8

39422

1

61712

7

MS21043-6

Purchased No

230 Each

523.0000 4 4



NUT



HL 11/07/13

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

40

112314

40

ST301

463

112314

463

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 17, 2011 2:28:14 PM

Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

113.0000

1

1



NUT



11/07/13

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291

37

117423

50

117677

25

x1

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING



11/07/13

Location

Loc Qty

Loc Code

FP

80

117460

80

FP-A

186

110915

139

115589

47

x8

M118077

NAS1611-013

Purchased

No

230

Each

168.0000

8

8



O-RING



11/07/13

Location

Loc Qty

Loc Code

FP

163

117291

123

117460

40

FP-A

5

116582

5

x5

x3

M117887

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

76.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST345

76

116381

26

117562

50

Purchased

No

250

Each

43.0000

2

2

AN960JD816



1/2" washer, Alum

1118078

Location

Loc Qty

Loc Code

FP-A

43

106043

43

Manufactured

No

250

Each

44.0000

1

1

D2741



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

44

61341

6

63589

38

Manufactured

No

250

Each

31.0000

2

2

D3493-1



Washer

Location

Loc Qty

Loc Code

ST062

31

66975

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250 Each

13.0000

2 2



Spacer



B66949

69895

10

MS21083C8

Purchased No

250 Each

113.0000

2 2



NUT



sf

11/7/13

## Location

## Loc Qty

## Loc Code

ST065

13

62218

13

## Location

## Loc Qty

## Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291

37

117423

50

117677

25

D2600-3-BENT

Manufactured No

110 Each

14.0000

1 1



Extrusion Bent



70142

1

10/06/17

## Location

## Loc Qty

## Loc Code

LG

14

66875

8

68137

6

D2744

Manufactured No

110 Each

31.0000

1 1



Cap



BE 11/06/20

## Location

## Loc Qty

## Loc Code

LG002

31

62715

3

65086

28

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 10

Work Order ID: 69712

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/17/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

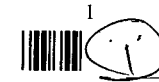
160 Each

6.0000



350 I Beam

69886



11/06/23

Location

Loc Qty

Loc Code

LG

6

67785

1

68285

5

D2743

Manufactured No

160 Each

139.0000



Crossbolt Spacer



BE 11/06/27  
B 69818 v8

Location

Loc Qty

Loc Code

LG001

139

67766

75

68251

64

D3490-3

Manufactured No

160 Each

42.0000



Cross Bolt Spacer



BE 11/06/27  
B 68952 v4

Location

Loc Qty

Loc Code

LG

26

68106

26

LG001

16

67774

16

D3490-1

Manufactured No

160 Each

69.0000



Cross Bolt Spacer



BE 11/06/27  
B 69510 v4

Location

Loc Qty

Loc Code

LG

67

67773

11

68105

56

LG001

2

62450

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

**GENERAL NOTES:**

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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PD11-05-17

RELEASED  
09-07-17

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 1	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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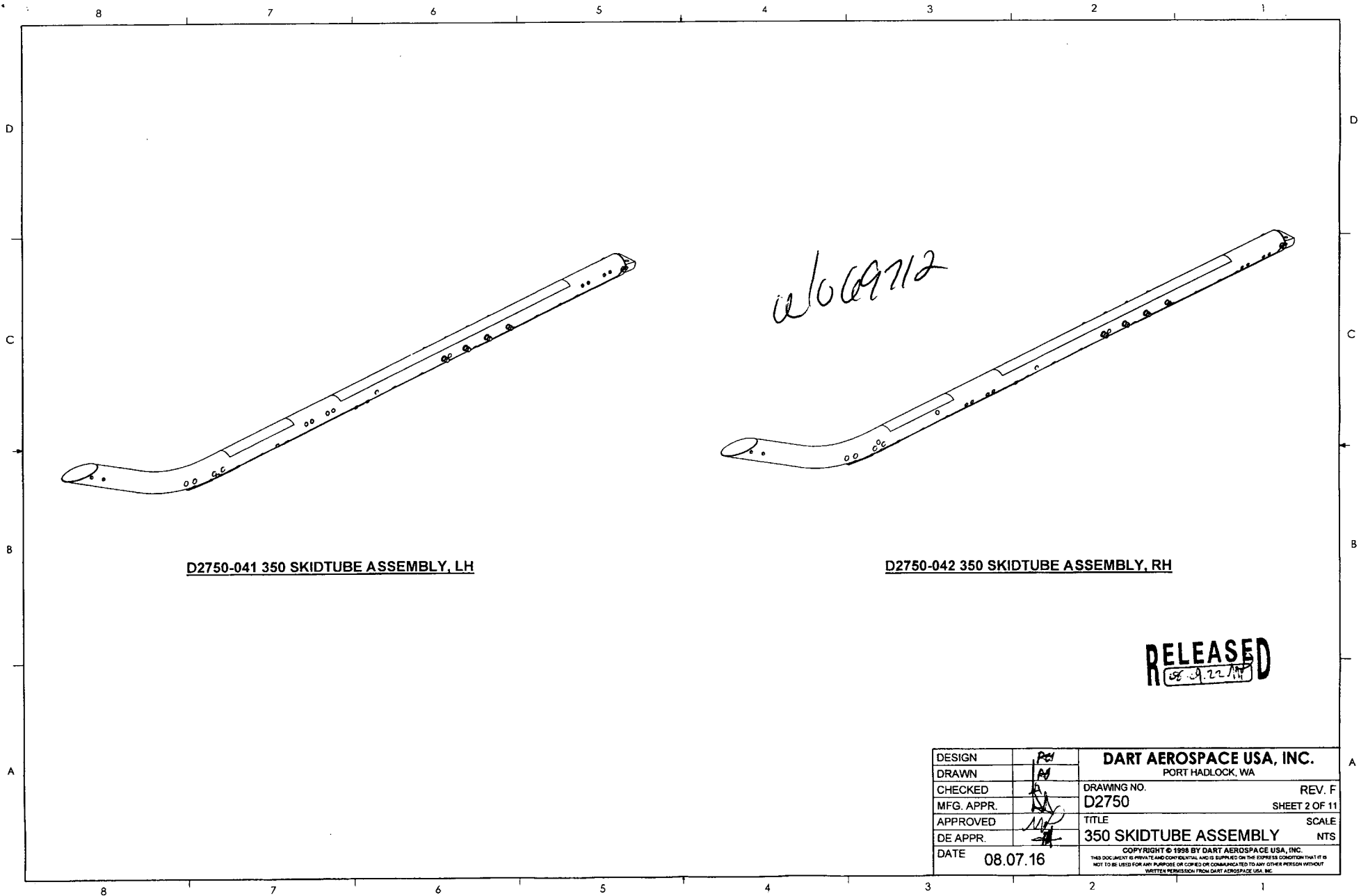
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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15-09-22-14

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CHECKED	SA	DRAWING NO. D2750	REV. F
MFG. APPR.	SA	SHEET 2 OF 11	
APPROVED	MEP	TITLE	SCALE
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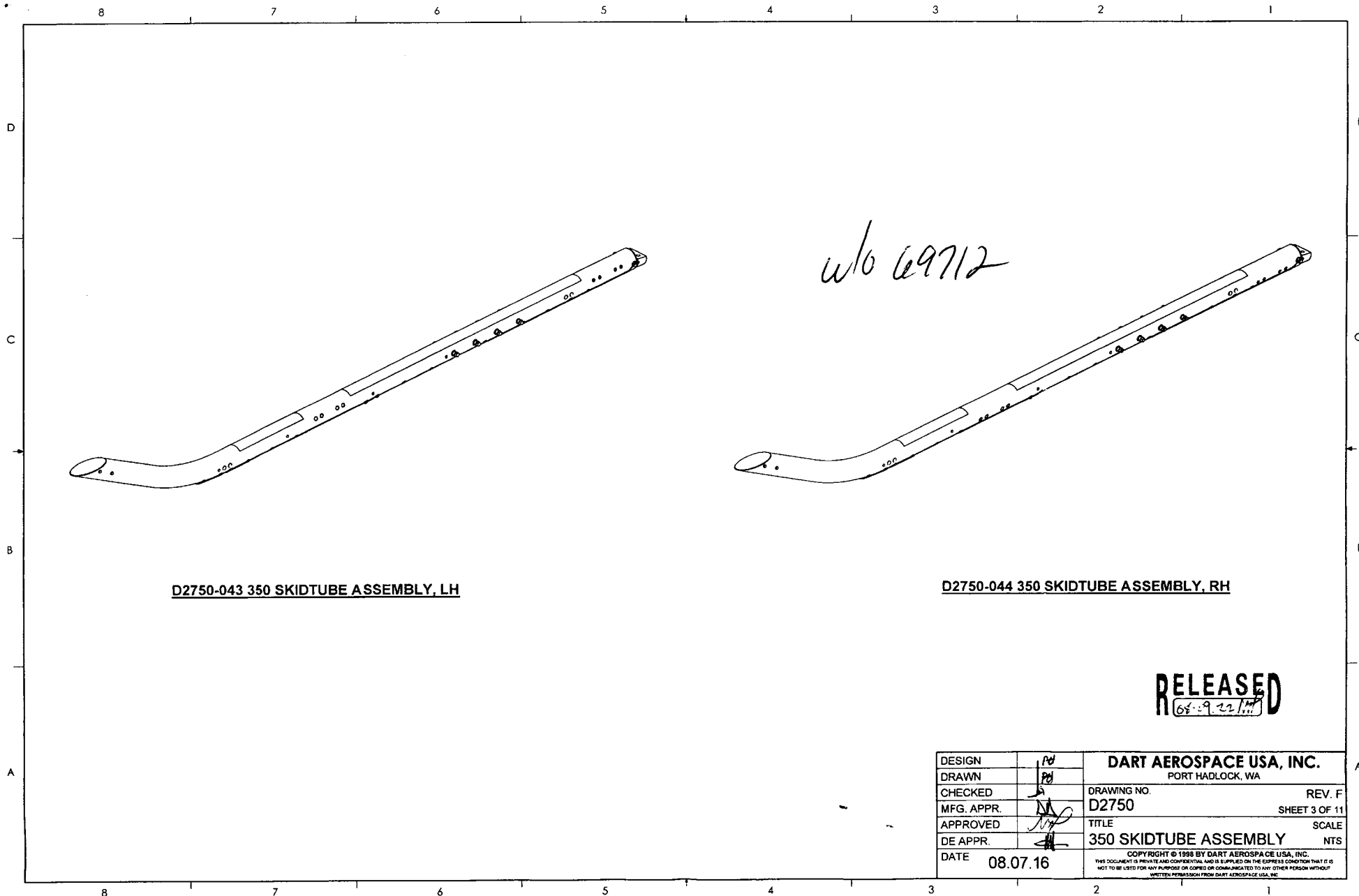
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**NOTE:** Date & initial all entries



W/O 69712

D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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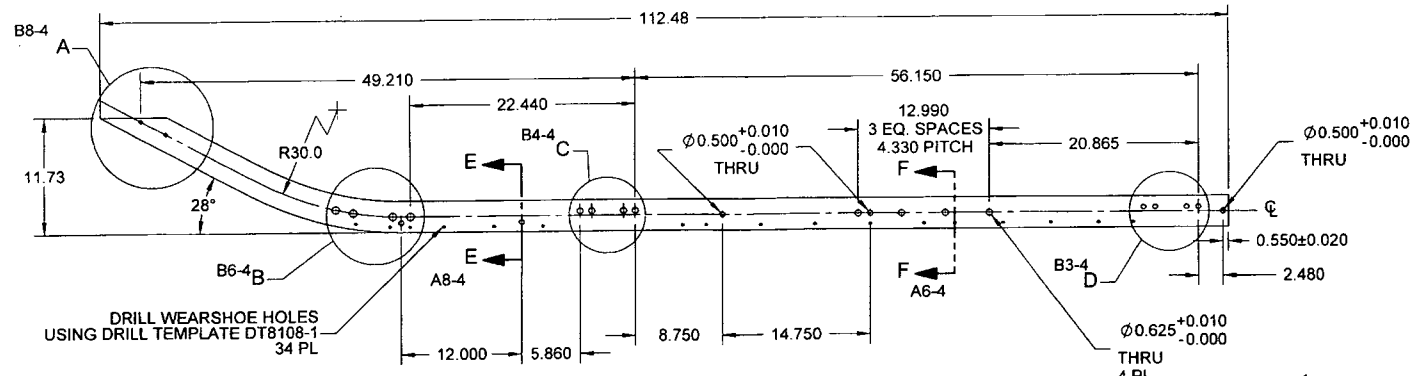
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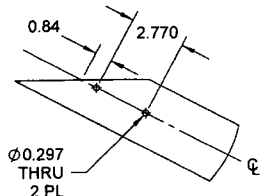
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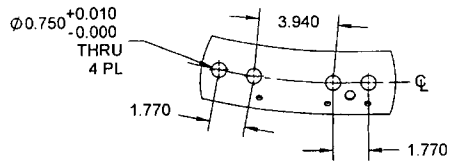


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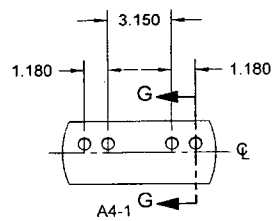
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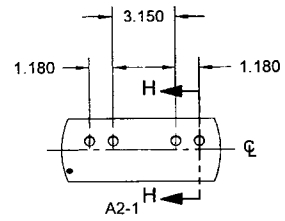
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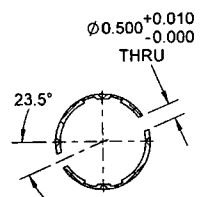
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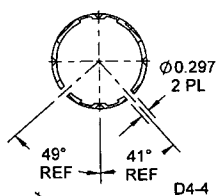
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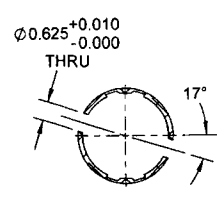
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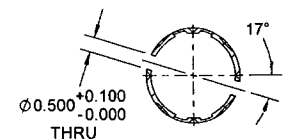
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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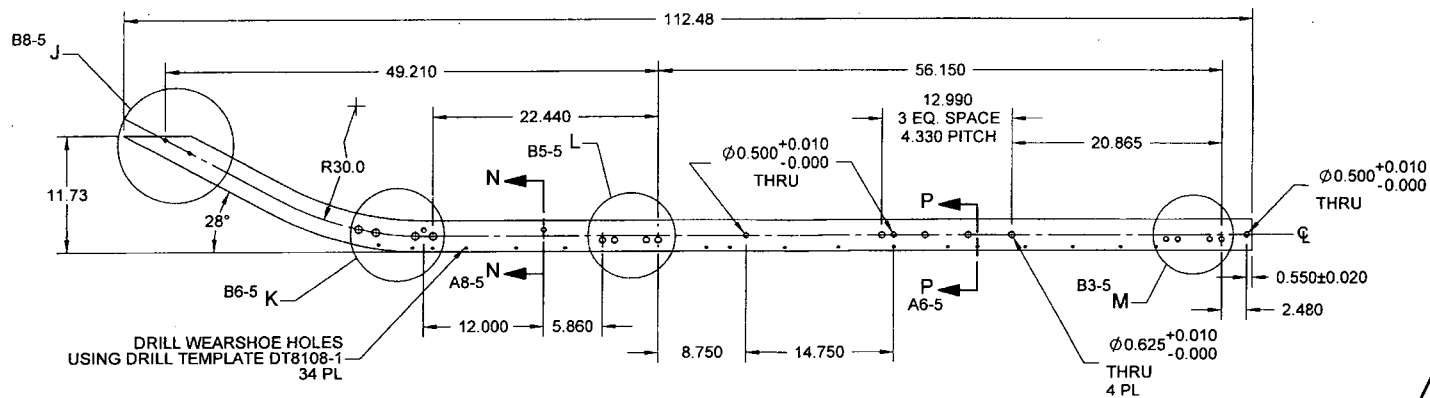
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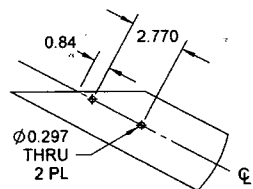
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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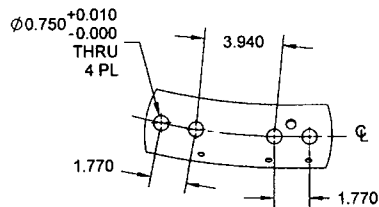




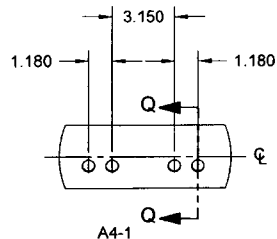
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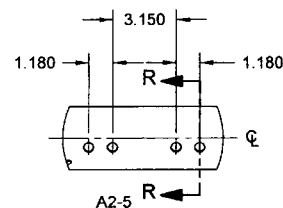
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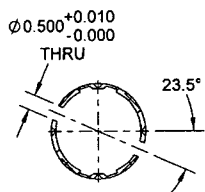
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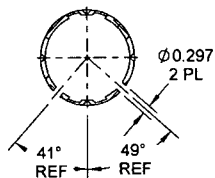
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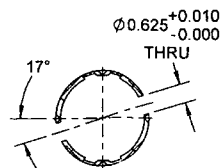
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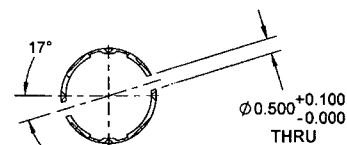
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

**B3-5**

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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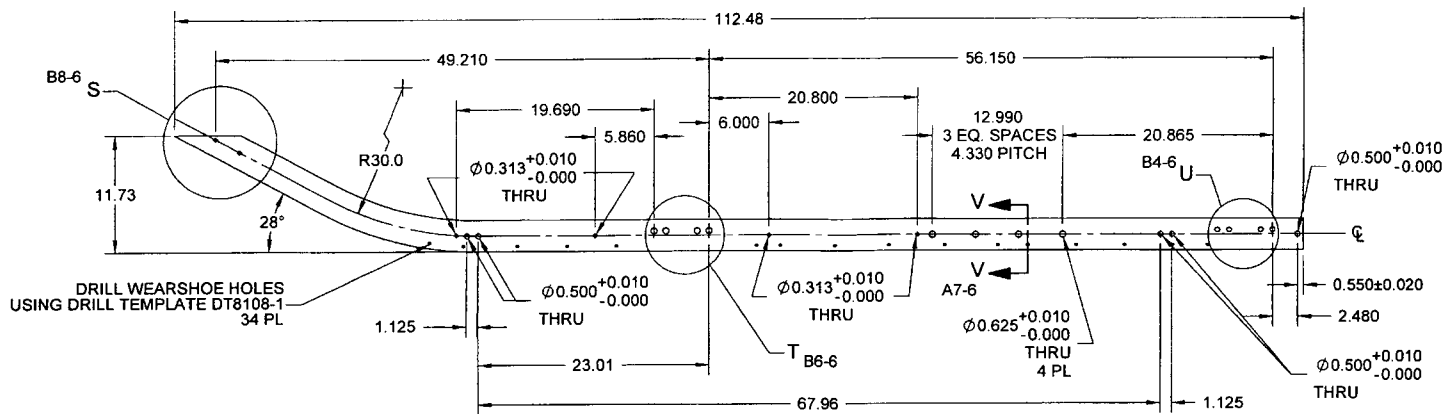
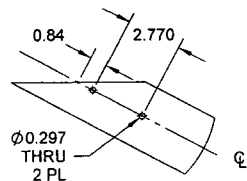
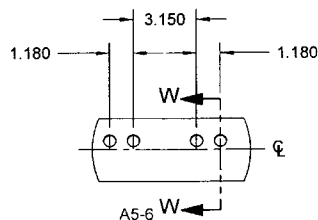
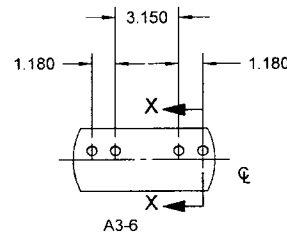
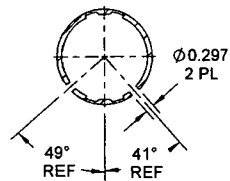
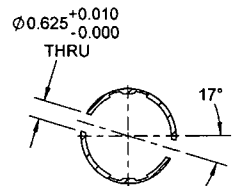
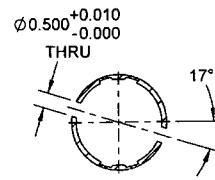
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**D2750-3 LH SKIDTUBE****DETAIL S**  
D8-6  
SCALE 2X**DETAIL T**  
C5-6  
SCALE 2X**DETAIL U**  
D3-6  
SCALE 2X**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL**RELEASED**  
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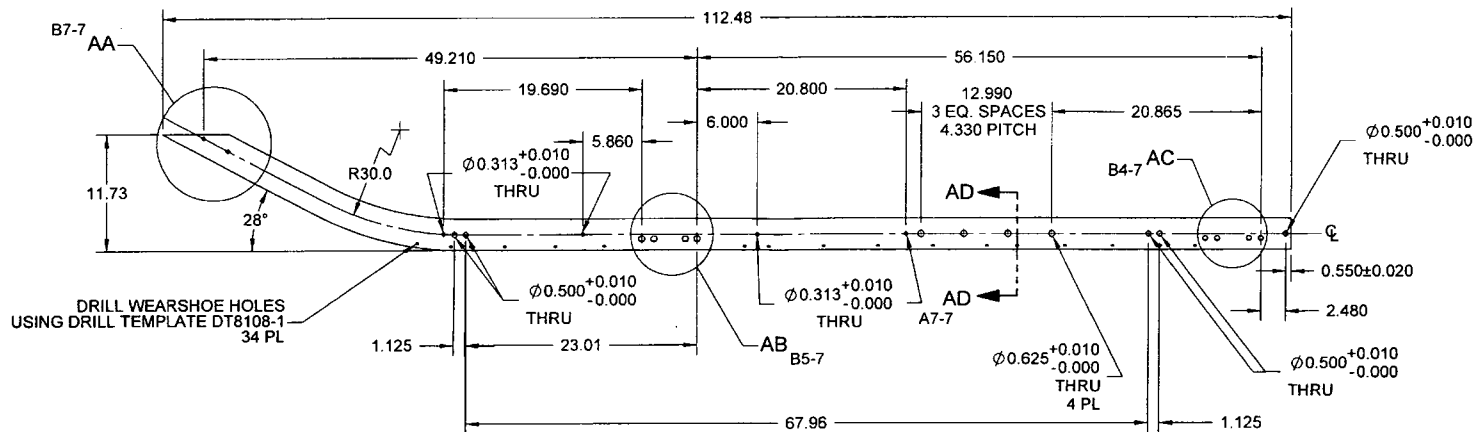
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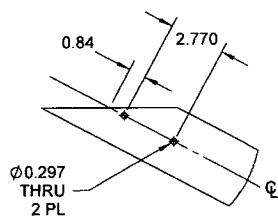
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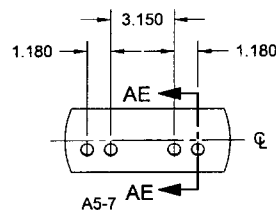
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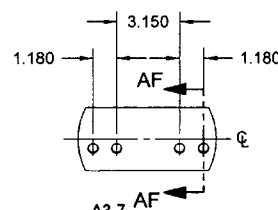
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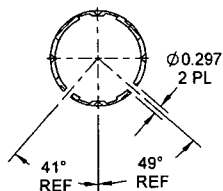
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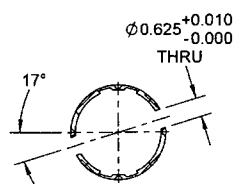
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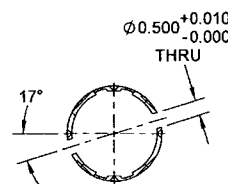
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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08-04-22-110

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MFG. APPR.	<i>RET</i>	D2750	SHEET 7 OF 11
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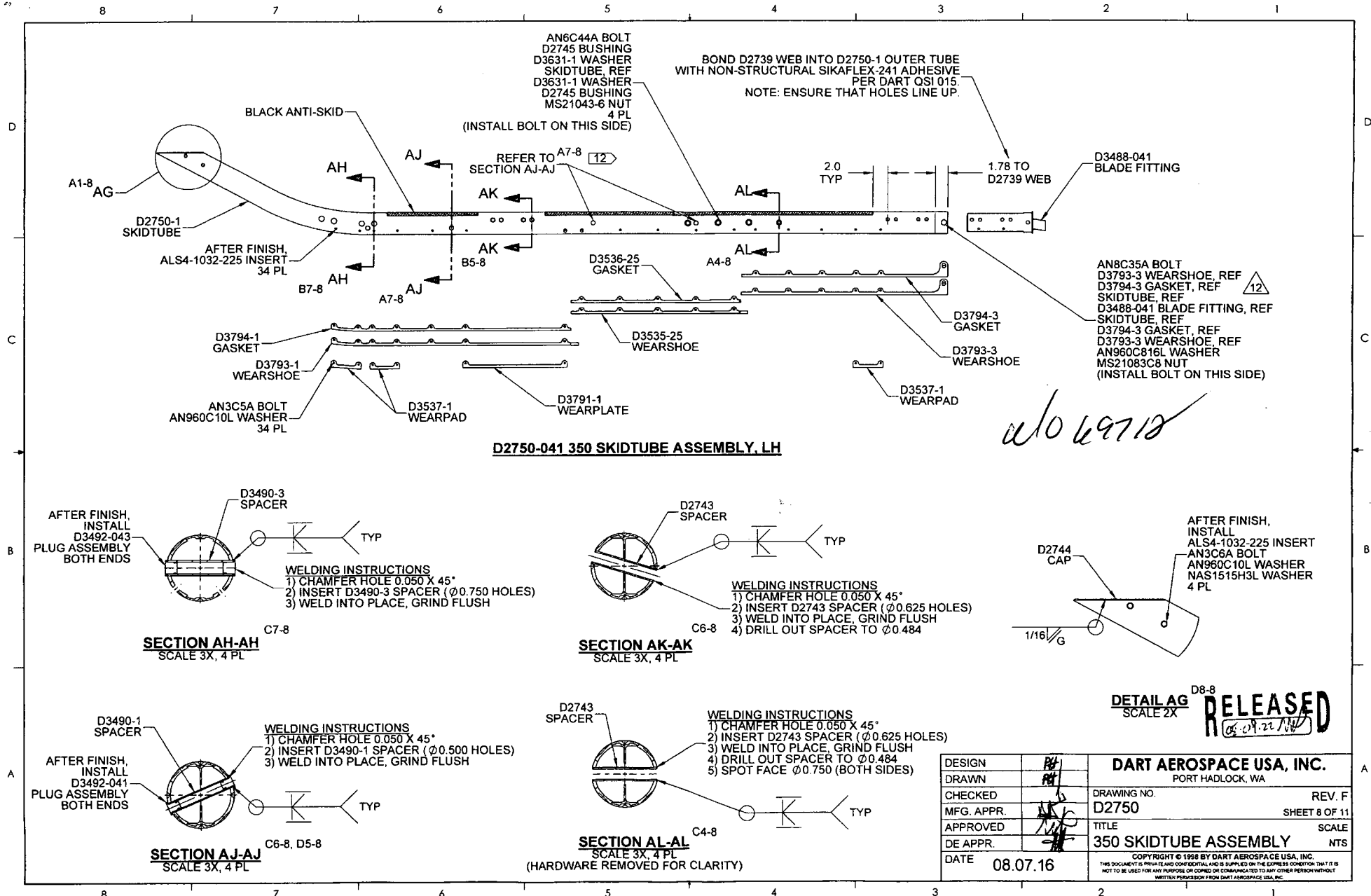
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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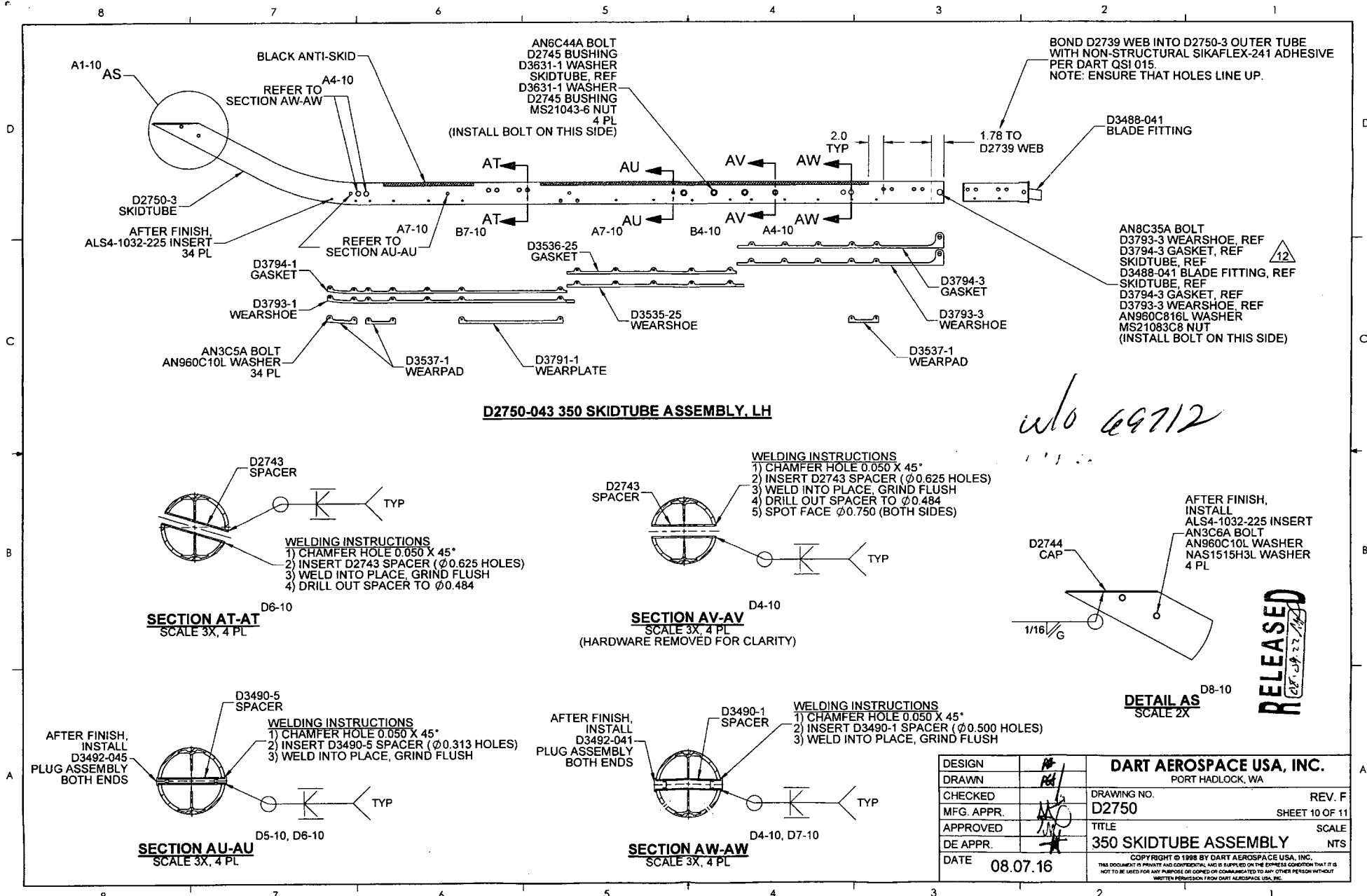
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

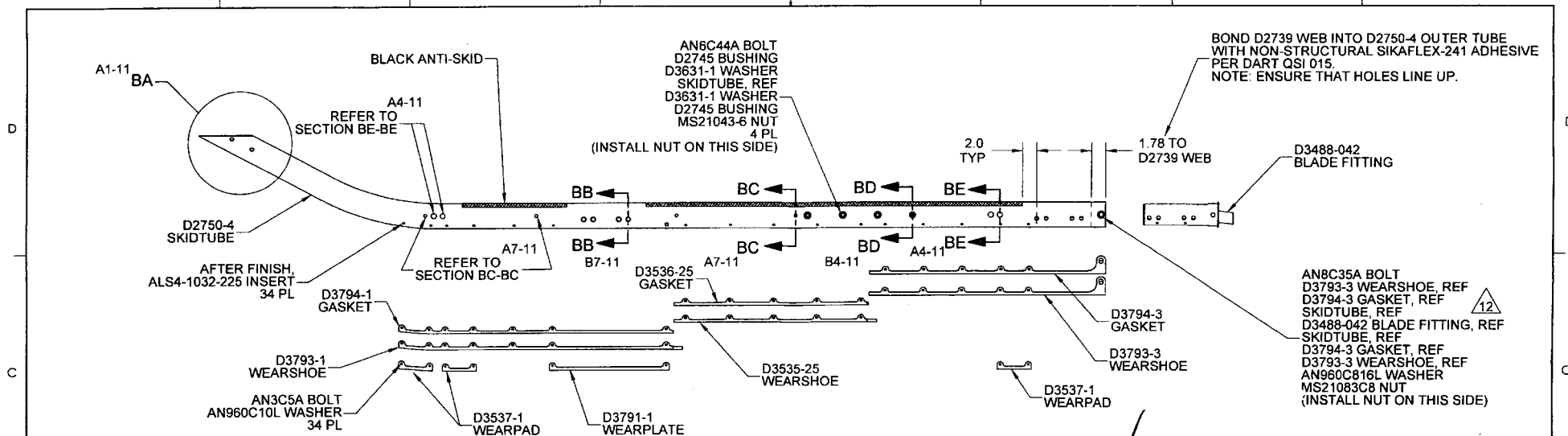
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

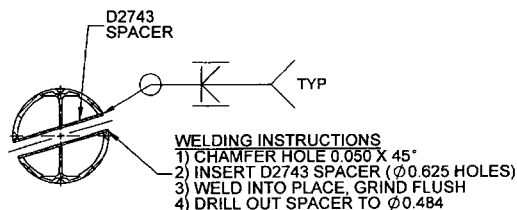
8 7 6 5 4 3 2 1



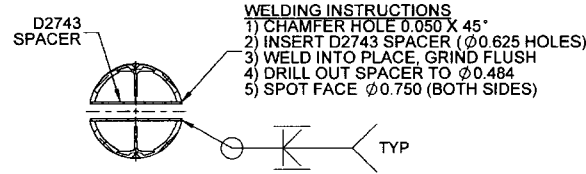
# **D2750-044 350 SKIDTUBE ASSEMBLY, RH**

u/o 69712

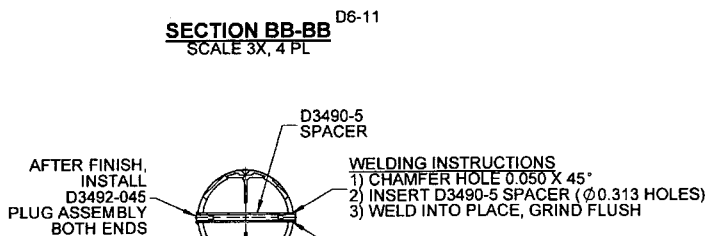
**RELEASED**



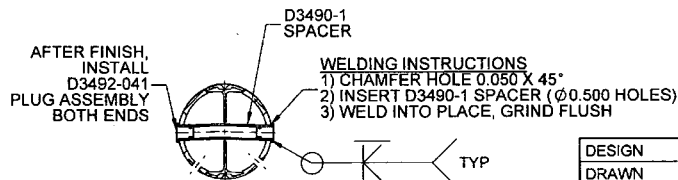
## **SECTION BB-BB** SCALE 3X, 4 PL



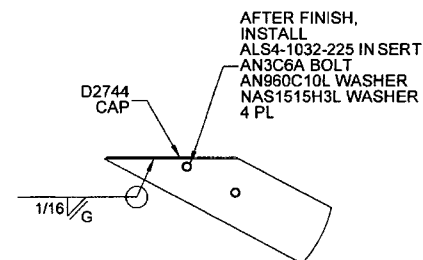
## **SECTION BD-BD** SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



## **SECTION BC-BC** SCALE 3X, 4 PL



## **SECTION BE-BE** SCALE 3X, 4 PL



## **DETAIL BA** SCALE 2X

DESIGN	HA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	<b>D2750</b>	SHEET 11 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1985 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 254

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 69872  
Part number: A350 636 011  
Description: 350  
Welding Process: Tig[☒] Mig[ ]  
Base material: aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Lewis Date of Test Coupon 11.06.08  
Welder Barclay Elliot Date of Test Coupon 11/06/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries